

Work Order ID 82790

\*82790\*

Page 1

April-10-12 7:54:55 AM

Item ID: D350-636-014

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Skidtube RH

Start Date: 10/04/2012 Start Qty: 1.00

\*1\*

Cust Item ID:

Required Date: 24/04/2012 Req'd Qty: 1.00

\*1\*

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/04/10 Tooling:

Date:

Run Start \*NR1\*

QC:

Date: SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D2750

F

D3492

C

0.00

0.00

100

\*100\*

DC

Document Control

DOCUMENT CONTROL

Memo

Photocopy blue file and type labels per PPP D350-636-014 CHG 006

B82790RH

MLJ 12-6-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 82790

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**\*N900040100\***

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Item Name: Skidtube RH

Start Date: 10/04/2012 Start Qty: 1.00 **\*1\***

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Required Date: 24/04/2012 Req'd Qty: 1.00 **\*1\***

Customer:

Reference:

Approvals: Process Plan: Date:

Tooling: Date:

Run Start **\*NR1\***

QC: Date:

SPC (Y/N): Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

110

0.00

**\*110\***

Skidtubes

0.00

Skidtubes

Skidtubes

Memo

1- Pick D2600-3 Bent

2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside AFT end per dwg D2750

3- Drill pilot holes for blade fitting bolt holes using DT8983. Open to 0.500", deburr.

4- Locate DT8329 off of blade fitting bolt holes and drill pilot holes for blade fitting

5- Drill only two fwd step holes using DT9616. Ensure proper positioning.

6- Drill pilot holes as per Dwg D2750 sheet 4 (D2750-4 details). Drill using drill Jig DT8150 & DT8864A for first side only DT8864B for second side (detail B)

7- Clecko DT8864B on second side of tube and drill pilot holes for detail B.  
\*\*\*SECOND SIDE\*\*\*

8- Open up holes for SECTION AW-AW to 0.375" (2 holes per side) and blade fitting location holes to 0.500" (total of 4 holes per side) as per dwg D2750. Open holes for ground handling and detail T to 0.500" (8 holes per side)

9- Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to 0.297".

10- Open up holes of Detail A to 0.297" (total of 2 holes per side)

*Handwritten signature and date: 12-04-24*

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**\*NS2\***

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**\*1\***

Cust Item ID:

Required Date: 24/04/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

11-Weld D2744 Cap as per Dwg D2750 and QSI 004. Fill grooves in bend left  
from bending as per QSI 004

A/R Aluminum Rod batch: M120854

BE 12/04/24

12-Grind welds flush as per Dwg D2750

11-04-25

120

QC10- Inspect visual per QSI004- ground welds

0.00

**\*120\***

QC

Memo

0.00

Quality Control

130

QC5- Inspect part completeness to step on W/O

0.00

**\*130\***

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**Work Order ID 82790****\*82790\***

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April-10-12 7:54:55 AM

Item ID: D350-636-014

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**\*N9000040100\***Setup Start **\*NS1\***

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Item Name: Skidtube RH

Stop **\*NS2\***

Start Date: 10/04/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 24/04/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

140

Chemical Conversion Coat per QSI005 4.1

0.00

**\*140\***

HandFinish

Memo

0.00

Hand Finishing

7/6 12-4-25

150

QC3- Inspect Part Finish

0.00

**\*150\***

QC

Memo

0.00

Quality Control

SAD 12-04-25

W/O: 82790		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
12/01/20	150	Qc3 change to Qc7  Already done DJ	SAD				

Part No: D350-636-014 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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\*1\*

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160

0.00

\*160\*

Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1-Open up holes section BE-BE 0.500" (4 per side) as per dwg D2750

2-Open holes section BC-BC 0.3125" (4 per side)

3-Open up holes of Detail AB and ground handling to 0.625" (total of 8 holes per side) as per dwg D2750.

4-Chamfer holes of section BE-BE, BC-BC, AB and ground handling (welding instructions on sheet 11)

5-Deburr and blow out all chips from inside of tube. Prepare tube for welding, remove alodine as required.

6-Bond web D2739 in place as per QSI 015

A/R Sikaflex-291

batch: M121221

exp. date: 13-1-4

7- Weld spacers D3490-1, D3490-5 and D2743 as per dwg D2750 & QSI004 (welding instructions on sheet 11)

A/R Aluminum Rod

batch: M120854

BE 12/05/11

8-Grind welds flush as per Dwg D2750

9-Spot face ground handling holes (total of 4 places per side) as per dwg D2750

10-Deburr holes

ST/CC 12-5-2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Stop

**\*NS2\***

Item Name: Skidtube RH

Start Date: 10/04/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 24/04/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Run Start

**\*NR1\***

Approvals: Process Plan:

Date:

Tooling:

Date:

Stop

**\*NR2\***

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

170

QC10- Inspect visual per QSI004- ground welds

0.00

**\*170\***

QC

Memo

0.00

Quality Control

180

QC5- Inspect part completeness to step on W/O

0.00

**\*180\***

QC

Memo

0.00

Quality Control

190

Pressure Wash per QSI005 4.3

0.00

**\*190\***

HandFinish

Memo

0.00

Hand Finishing

Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.

7/6 12-5-2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID 82790

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April-10-12 7:54:55 AM

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\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Item Name: Skidtube RH

Stop \*NS2\*

Start Date: 10/04/2012 Start Qty: 1.00

\*1\*

Cust Item ID:

Required Date: 24/04/2012 Req'd Qty: 1.00

\*1\*

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID Tool # Plan Accept Reject Reject Insp.  
Code Qty Qty Number Stamp

200

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

\*200\*

Powdercoat

Memo

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

3:20  
320  
3:50  
0.00  
0.00

Powder Coating

210

QC3- Inspect Part Finish

0.00

\*210\*

QC

Memo

Inspect for foreign object per QSI 024

Quality Control

1X

M-L  
12/05/02

1211x d

HL 12/05/03

M121134

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID 82790

\*82790\*

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April-10-12 7:54:55 AM

Item ID: D350-636-014

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\*N9000040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Skidtube RH

Start Date: 10/04/2012 Start Qty: 1.00

\*1\*

Cust Item ID:

Required Date: 24/04/2012 Req'd Qty: 1.00

\*1\*

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

230

0.00

\*230\*

HandFinishing

HandFinish

Hand Finishing

Memo

0.00

1-Install inserts as per dwg D2750

2-assemble o'ring as per dwg D3492 and apply o'ring lube  
A/R 55-o'ring lube batch: AA110348

3-Assemble tube hardware as per dwg D2750 sikaflex batch: AA1121221 1316

4-Inspect For Foreign Objects

5-Spray inside of tube with "LPS-3" batch: 101A

6-Install blade fitting D3488-041, wearshoe

SIKA FLEX 241

BATCH: AA121221

EXP DATE: 1310

7-assemble o'ring to plug as per dwg D3492 and apply o'ring lube

A/R 55-o'ring lube batch: AA110348

8-Coat all exposed fasteners with "LPS Procyon" batch: AA114596

1 RH

d

all ulog 03

Pro

Dart Aerospace Ltd

W/O: 8290		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D350-636-014 PAR #:            Fault Category: Skid tube NCR: Yes No DQA OK Date: 12/6/26  
 Resolution: Rework Disposition: Rework QA: N/C Closed: OK Date: 12/6/27

NCR: 12.1527		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12/6/23	230	Found that <del>the</del> Durnin Assembly D3488-04/142 Doesnt Align with skid tube. R.C. Bol on D3488 outer and Humon Drill of Skid (Process)	GP 12.06.07	Drill out 3 Aft mist holes Oh x5 on <del>the</del> skid to max tol.  Drill Oh x5 holes in D3488 to max tol	GP 12-6-6	S 12/6/26	GP 12.06.07	S 12/6/23
			GP 12.06.07	touch up Alodin as per 037407 + Re Assemble.	GP 12-6-18		GP 12.06.07	S 12/6/23

NOTE: Date & initial all entries



**Work Order ID 82790****\*82790\***

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April-10-12 7:54:55 AM

Item ID: D350-636-014

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Item Name: Skidtube RH

Stop **\*NS2\***

Start Date: 10/04/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 24/04/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursTool ID Tool # Plan  
Code Accept Reject Reject Insp.  
Qty Qty Number Stamp

240

QC5- Inspect part completeness to step on W/O

0.00

**\*240\***

QC

Memo

0.00

Quality Control

250

Pick Kit

0.00

**\*250\***

Packaging

Memo

0.00

Packaging

260

QC4- 100% Inspect kits for completeness

0.00

**\*260\***

QC

Memo

0.00

Quality Control

8/7/06/18

12/6/18  
EST

8/7/06/20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Reference:

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Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

270

**\*270\***

Packaging

Packaging

Memo

0.00

0.00

Packaging

Package as per PPP D350-636-014

280

**\*280\***

QC

Quality Control

QC21- Final Inspection - Work Order Release

Memo

0.00

0.00

*Lo 72*

*Rev 1*

*01/06/2012*

*12/10/2012*

*MSC 12/06/2012*

W/O:		WORK ORDER CHANGES					
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**NOTE:** Date & initial all entries

# Picklist Print

April-10-12 7:55:00 AM

Page 1

Work Order ID: 82790

\*82790\*

Parent Item: D350-636-014

\*D350-636-014\*

Parent Item Name: Skidtube RH

Start Date: 10/04/2012

Required Date: 24/04/2012

Start Qty: 1.00

Required Qty: 1.00

## Comments:

IPP Rev:H02.09.25Rearranged procedure stepsKJ  
 IPP Rev:I05.12.08Rearranged procedure stepsEC  
 IPP Rev:J06.03.30Per rev. D EC  
 IPP Rev:L 07-07-28 Added SS Wearplates(Rev E) JLM Verified By:EC  
 IPP Rev:M 08-09-23 revF as per dwg DD verified by:ec IPP Rev:N  
 10.06.22 revise seq110 DD verf:EC IPP Rev:O 10.10.01 as  
 per IIN revH DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2600-3-BENT

Manufactured No

110

Each

27.0000

1

\*D2600-3-BENT\*

Extrusion Bent

### Location

### Loc Qty

### Loc Code

LG

27

66875

7

73253

1

75021

1

75022

1

75023

1

81330

4

82347

12

\*\*

①

12-04-24

D2739

Manufactured No

160

Each

3.0000

1

\*D2739\*

350 I Beam

### Location

### Loc Qty

### Loc Code

LG

3

72155

1

81508

1

82122

1

\*\*

①

CF 12-4-25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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28.4.01	70	70		Produce				

NOTE: Date & initial all entries

# Picklist Print

April-10-12 7:55:00 AM

Page 2

Work Order ID: 82790

Parent Item: D350-636-014

Parent Item Name: Skidtube RH

**\*82790\***

**\*D350-636-014\***

Start Date: 10/04/2012

Required Date: 24/04/2012

Start Qty: 1.00

Required Qty: 1.00

D2743

Manufactured No

160 Each

314.0000 8 8

**\*D2743\***

Crossbolt Spacer

\*\*

Location

Loc Qty

Loc Code

LG001

314

67766

4

68251

3

73403

64

74445

1

78603

2

79517

30

D2744

Manufactured No

160 Each

42.0000 1 1

**\*D2744\***

Cap

\*\*

Location

Loc Qty

Loc Code

LG002

42

62715

1

70881

3

78900

38

D3490-1

Manufactured No

160 Each

104.0000 4 4

**\*D3490-1\***

Cross Bolt Spacer

\*\*

Location

Loc Qty

Loc Code

LG

95

81976

95

LG001

9

62450

2

74875

4

77042

3

April-10-12 7:55:00 AM

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

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Work Order ID: 82790

**\*82790\***

Parent Item: D350-636-014

**\*D350-636-014\***

Parent Item Name: Skidtube RH

Start Date: 10/04/2012

Required Date: 24/04/2012

Start Qty: 1.00

Required Qty: 1.00

D3490-5

Manufactured No

160 Each

45.0000 4 4

**\*D3490-5\***

Cross Bolt Spacer

\*\*

BE 12/05/01

Location

Loc Qty

Loc Code

LG	25
78958	25
LG001	20
59230	20

2
2

ALS4-1032-225

Purchased No

230 Each

2,461.000 38 38

**\*ALS4-1032-225\***

Insert

\*\*

ll n/05/03

Location

Loc Qty

Loc Code

ST281	2438
108696	146
110768	62
118386	55
118966	68
120671	107
121269	2000
ST282	23
120410	10
120451	13

Y 38

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Work Order ID: 82790

\*82790\*

Parent Item: D350-636-014

\*D350-636-014\*

Parent Item Name: Skidtube RH

Start Date: 10/04/2012

Required Date: 24/04/2012

Start Qty: 1.00

Required Qty: 1.00

AN3C5A Purchased No 230 Each 1,596.000 34 34

\*AN3C5A\*

Bolt

\*\*

AL 12105103

Location	Loc Qty	Loc Code	
FP001	7	11121068	34
115835	7		
ST350	1589		
116419	28		
117343	13		
117764	7		
117872	2		
119749	23		
120423	516		
1210168	500		
121255	500		

AN3C6A Purchased No 230 Each 509.0000 4 4

\*AN3C6A\*

BOLT

\*\*

AL 12105103

Location	Loc Qty	Loc Code	
FP001	1		
111982	1		
ST351	508		
111982	2		
116419	23		
116549	2		
116704	12		
117619	10		
117688	1		
117872	5		
118422	13		
119449	21		
120423	19		
120693	400		84

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Work Order ID: 82790

Parent Item: D350-636-014

Parent Item Name: Skidtube RH

\*82790\*

\*D350-636-014\*

Start Date: 10/04/2012

Required Date: 24/04/2012

Start Qty: 1.00

Required Qty: 1.00

AN6C44A

Purchased

No

230

Each

170.0000

4

4

\*AN6C44A\*

BOLT

\*\*

M 12/05/03

Location

Loc Qty

Loc Code

FG

2

103964

2

ST343

168

120143

25

120465

23

121013

20

121167

100

X21

AN8C35A

Purchased

No

230

Each

104.0000

1

1

\*AN8C35A\*

BOLT

\*\*

M 12/05/03

Location

Loc Qty

Loc Code

FP002

103

115960

1

117834

7

118286

45

121275

50

V1

ST346

1

114442

0

115188

0

115960

1

AN960C10L

NAS1149C0332  
R

Purchased

No

230

Each

0.0000

38

38

\*AN960C10I \*

washer

M 12/5/09

\*\*

(X38)

M 12/05/03

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**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Work Order ID: 82790

\*82790\*

Parent Item: D350-636-014

\*D350-636-014\*

Parent Item Name: Skidtube RH

Start Date: 10/04/2012

Required Date: 24/04/2012

Start Qty: 1.00

Required Qty: 1.00

D2745

Manufactured No

230

Each

48.0000

8

8

\*D2745\*

Bushing

\*\*

u 12/05/03

## Location

## Loc Qty

## Loc Code

FP

46

B81964

x8

79518

46

FP001

2

69529

1

76142

1

D3488-042

Manufactured No

230

Each

15.0000

1

1

\*D3488-042\*

Blade Fitting Assembly, RH

\*\*

u 12/05/03

## Location

## Loc Qty

## Loc Code

FP002

15

B82258

x1

62003

1

75068

8

77015

6

D3492-1

Manufactured No

230

Each

30.0000

8

8

\*D3492-1\*

Plug

\*\*

u 12/05/03

## Location

## Loc Qty

## Loc Code

FP002

30

69531

8

74444

2

76235

4

77037

16

B83098

x8

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

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Work Order ID: 82790

**\*82790\***

Parent Item: D350-636-014

**\*D350-636-014\***

Parent Item Name: Skidtube RH

Start Date: 10/04/2012

Required Date: 24/04/2012

Start Qty: 1.00

Required Qty: 1.00

D3492-5 Manufactured No

230 Each 72.0000 8 8

**\*D3492-5\***

Plug

\*\*

AL 12/05/03

Location	Loc Qty	Loc Code
FP	40	
78792	40	
FP002	32	
77044	32	

D3535-25 Manufactured No

230 Each 22.0000 1 1

**\*D3535-25\***

Wearshoe

\*\*

AL 12/05/03

Location	Loc Qty	Loc Code
FP001	22	
62233	1	
80331	10	
81357	11	

D3536-25 Manufactured No

230 Each 22.0000 1 1

**\*D3536-25\***

Gasket

\*\*

AL 12/05/03

Location	Loc Qty	Loc Code
FP	14	
81342	14	
FP002	8	
78902	8	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

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Work Order ID: 82790

**\*82790\***

Parent Item: D350-636-014

**\*D350-636-014\***

Parent Item Name: Skidtube RH

Start Date: 10/04/2012

Required Date: 24/04/2012

Start Qty: 1.00

Required Qty: 1.00

D3537-1 Manufactured No

230

Each

75.0000

3

3

**\*D3537-1\***

Wearpad

\*\*

*9U 12/05/03*

Location

Loc Qty

Loc Code

FG

10

1381959

13

79833

10

FP002

65

69817

5

80337

11

81361

49

D3631-1 Manufactured No

230

Each

227.0000

8

8

**\*D3631-1\***

Washer

\*\*

*9U 12/05/03*

Location

Loc Qty

Loc Code

FG

100

81874

100

V 9/6

ST072

127

68062

2

75548

125

D3672-1 Manufactured No

230

Each

1,022.000

8

8

**\*D3672-1\***

Phenolic Washer

\*\*

Location

Loc Qty

Loc Code

FP001

34

66821

34

ST060

988

72229

4

76277

484

80369

500

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Work Order ID: 82790

**\*82790\***

Parent Item: D350-636-014

**\*D350-636-014\***

Parent Item Name: Skidtube RH

Start Date: 10/04/2012

Required Date: 24/04/2012

Start Qty: 1.00

Required Qty: 1.00

D3791-1 Manufactured No

230 Each 25.0000 1 1

**\*D3791-1\***

Wearplate

\*\*

all 12/05/03

Location	Loc Qty	Loc Code
FP002	25	B82168
62239	2	
78897	7	
82168	16	

D3793-1 Manufactured No

230 Each 26.0000 1 1

**\*D3793-1\***

Wearshoe

\*\*

all 12/05/03

Location	Loc Qty	Loc Code
FP001	26	
78901	10	
82171	16	

D3793-3 Manufactured No

230 Each 30.0000 1 1

**\*D3793-3\***

Wearshoe

\*\*

all 12/05/03

Location	Loc Qty	Loc Code
FP001	23	
80434	11	
82166	12	
FP002	7	
78935	7	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Work Order ID: 82790

Parent Item: D350-636-014

Parent Item Name: Skidtube RH

\*82790\*

\*D350-636-014\*

Start Date: 10/04/2012

Required Date: 24/04/2012

Start Qty: 1.00

Required Qty: 1.00

D3794-1

Manufactured No

230

Each

39.0000

1

1

\*D3794-1\*

Gasket

\*\*

yl 12/05/03

Location

Loc Qty

Loc Code

FP

23

82167

23

FP002

16

75042

4

80435

12

D3794-3

Manufactured No

230

Each

23.0000

1

1

\*D3794-3\*

Gasket

\*\*

yl 12/05/03

Location

Loc Qty

Loc Code

FP002

23

74530

2

80436

21

MS21043-6

Purchased No

230

Each

765.0000

4

4

\*MS21043-6\*

NUT

\*\*

yl 12/05/03

Location

Loc Qty

Loc Code

FG

20

103693

20

ST301

745

112314

39

117887

6

118384

200

120308

500

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC-Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

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Work Order ID: 82790

Parent Item: D350-636-014

Parent Item Name: Skidtube RH

\*82790\*

\*D350-636-014\*

Start Date: 10/04/2012

Required Date: 24/04/2012

Start Qty: 1.00

Required Qty: 1.00

MS21083C8

Purchased

No

230

Each

105.0000

1

1

\*MS21083C8\*

NUT

\*\*

44 12/05/03

## Location

## Loc Qty

## Loc Code

304

50

121185

50

FP002

1

X1

115884

1

ST303

5

115884

0

118077

1

119309

2

119638

2

ST304

49

120142

7

120731

17

121011

25

NAS1149C0832R

Purchased

No

230

Each

293.0000

1

1

\*NAS1149C0832R\*

WASHER

\*\*

44 12/05/03

## Location

## Loc Qty

## Loc Code

ST297

293

114915

293

X1

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Work Order ID: 82790

**\*82790\***

Parent Item: D350-636-014

**\*D350-636-014\***

Parent Item Name: Skidtube RH

Start Date: 10/04/2012

Required Date: 24/04/2012

Start Qty: 1.00

Required Qty: 1.00

NAS1515H3L

Purchased

No

230

Each

190.0000

4

4

**\*NAS1515H3I \***

WASHER

\*\*

*all 12/05/03*

Location

Loc Qty

Loc Code

FG

40

102472

40

ST277

150

118686

3

119438

1

120360

96

121243

50

*x4*

NAS1611-005

Purchased

No

230

Each

204.0000

8

8

**\*NAS1611-005\***

O-RING

\*\*

*all 12/05/03*

Location

Loc Qty

Loc Code

FP001

204

106099

31

114220

105

119438

68

*x 8*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Work Order ID: 82790

Parent Item: D350-636-014

Parent Item Name: Skidtube RH

**\*82790\***

**\*D350-636-014\***

Start Date: 10/04/2012

Required Date: 24/04/2012

Start Qty: 1.00

Required Qty: 1.00

NAS1611-010

Purchased

No

230

Each

259.0000

8

8

**\*NAS1611-010\***

O-RING

\*\*

11/05/03

## Location

## Loc Qty

## Loc Code

FP

50

11121415

V8

110915

0

120770

50

FP001

209

110915

14

117460

8

118077

1

118612

3

119438

47

120986

50

121166

36

121259

50

AN8C21A

Purchased

No

250

Each

121.0000

2

2

**\*AN8C21A\***

BOLT

\*\*

SP

## Location

## Loc Qty

## Loc Code

ST343

121

118758

5

120094

26

121067

20

121167

20

121275

50

2x

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

April-10-12 7:55:00 AM

Work Order ID: 82790

Parent Item: D350-636-014

Parent Item Name: Skidtube RH

**\*82790\***

**\*D350-636-014\***

Start Date: 10/04/2012

Required Date: 24/04/2012

Start Qty: 1.00

Required Qty: 1.00

D2741

Manufactured No

250

Each

63.0000

1

**\*D2741\***

Blade, 350 Skidtube

\*\*

Location

Loc Qty

Loc Code

ST

-10

ST466

73

71856

1

76984

22

79516

40

D3493-1

Manufactured No

250

Each

46.0000

2

**\*D3493-1\***

Washer

\*\*

Location

Loc Qty

Loc Code

ST050

46

70697

2

77573

4

78835

40

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

April-10-12 7:55:00 AM

Work Order ID: 82790

Parent Item: D350-636-014

Parent Item Name: Skidtube RH

\*82790\*

\*D350-636-014\*

Start Date: 10/04/2012

Required Date: 24/04/2012

Start Qty: 1.00

Required Qty: 1.00

MS21083C8

Purchased

No

250

Each

105.0000

2

2

\*MS21083C8\*

NUT

\*\*

M121349

Location

Loc Qty

Loc Code

304

50

121185

50

FP002

1

115884

1

ST303

5

115884

0

118077

1

119309

2

119638

2

ST304

49

120142

7

120731

17

121011

25

NAS1149D0863J

Purchased

No

250

Each

211.0000

2

2

\*NAS1149D0863.J\*

WASHER

\*\*

121612

OP

Location

Loc Qty

Loc Code

ST298

211

118078

36

119307

75

120308

100

8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN960C10L	WASHER
1	1	1	1	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21043C8	NUT
4	4	4	4	NAS1515H3L	WASHER

# GENERAL NOTES:

- MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- FINISH:  
ACID ETCH, ALONDE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.  
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: N/A
- IDENTIFICATION: N/A
- WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- WELD PER DART QSI 004
- INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES ( $\phi$  0.297) FOR WEARSHOE INSERTS
- FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:  
MINIMUM YIELD TENSILE STRENGTH = 35 KSI  
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS.  
COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY. CLEAN EXCESS OFF  
POWDER COATING WITH MEK DEGREASER.
- SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

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WITHOUT NOTICE  
WORK ORDER

NO. 82790 MLCJ  
12/04/10

RELEASED

F	INCORPORATE DSI 9413; QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/-3 REPLACES D3535-13/-35 (ZN C8-1); D3794-1/-3 REPLACES D3536-13/-35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL). WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON: REF. NCR 08-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS, CHANGE INSERTS; ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515H8L; REMOVE D2741 QTY (2) AN960C816; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEC 9133/9157	PH	06.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	98.11.16
B	CHANGE MS24694-S293 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN	PC		
DRAWN	RAH		
CHECKED			
MFG. APPR.	AS		
APPROVED	AS		
DE APPR.	AS		
DATE	08.07.16		

DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWING NO. D2750	REV. F SHEET 1 OF 11
TITLE 350 SKIDTUBE ASSEMBLY	SCALE NTS
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W/O:		WORK ORDER CHANGES					
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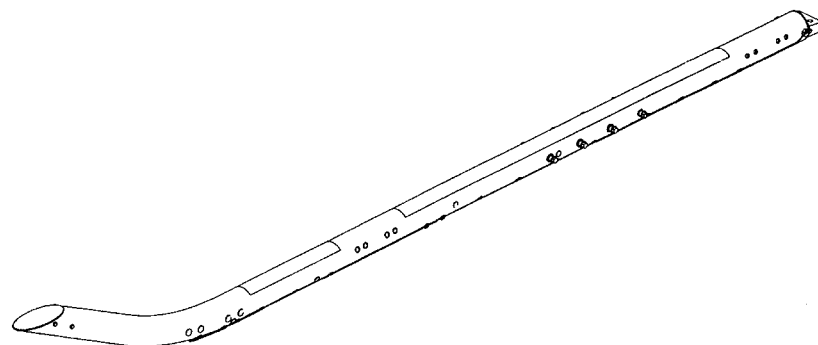
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

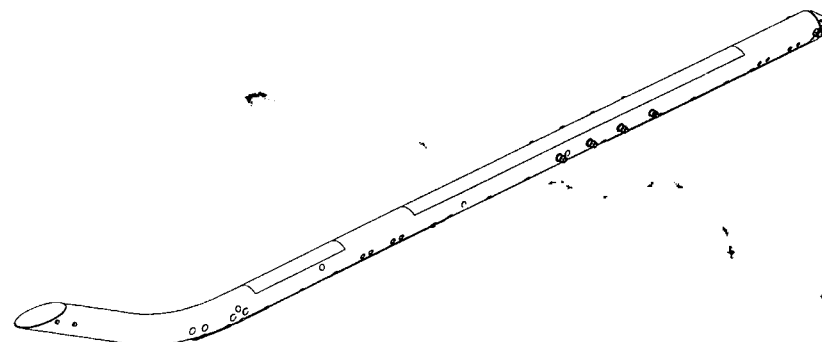
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

02790



D2750-041 350 SKIDTUBE ASSEMBLY, LH



D2750-042 350 SKIDTUBE ASSEMBLY, RH

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08-09-22/14

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CHECKED	PA	DRAWING NO. <b>D2750</b>	REV. F
MFG. APPR.	MA	SHEET 2 OF 11	
APPROVED	MA	TITLE	SCALE
DE APPR.	MA	<b>350 SKIDTUBE ASSEMBLY</b>	
DATE	08.07.16	NTS	

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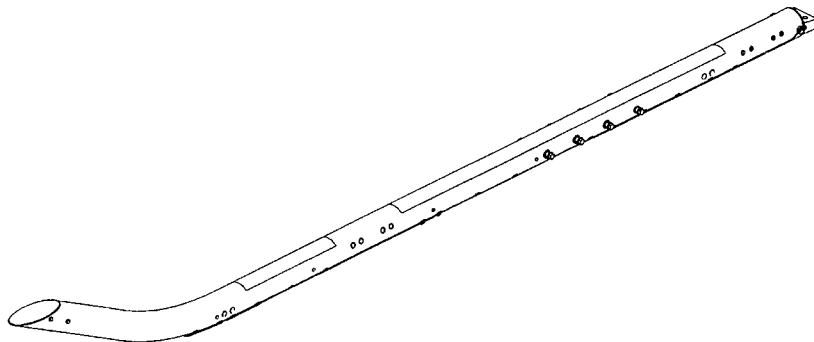
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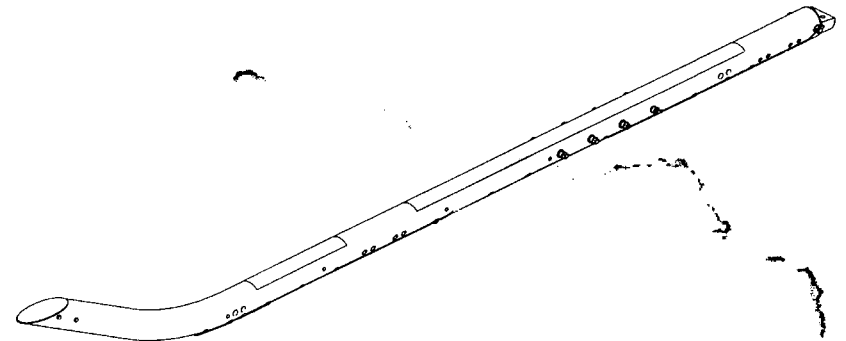
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

82790



D2750-043 350 SKIDTUBE ASSEMBLY, LH



D2750-044 350 SKIDTUBE ASSEMBLY, RH

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68-09-11/100

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MFG. APPR.	JA	D2750	SHEET 3 OF 11
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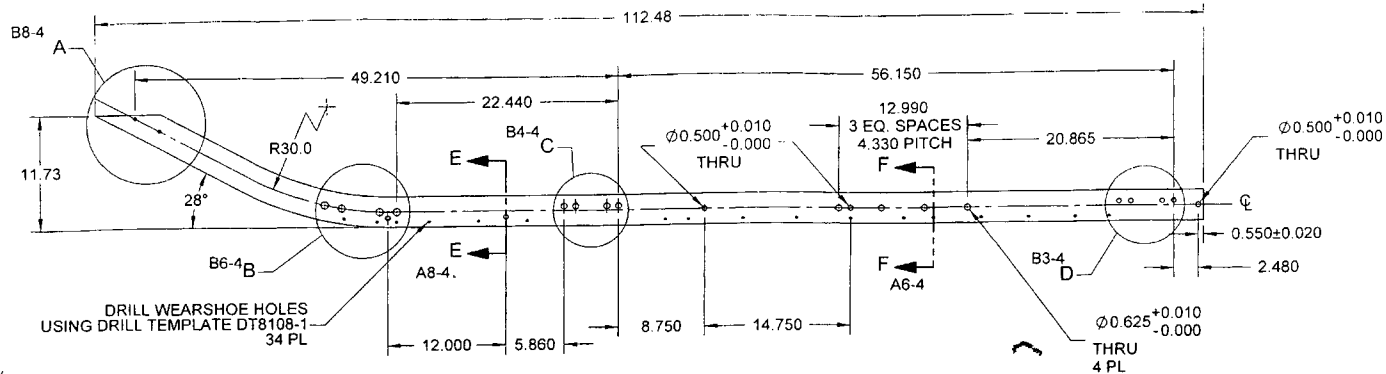
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

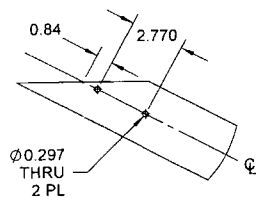
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

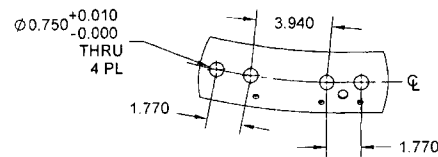
**NOTE:** Date & initial all entries



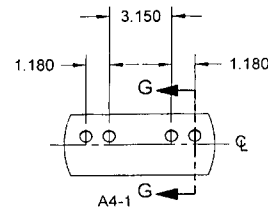
**D2750-1 LH SKIDTUBE**



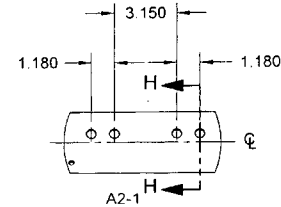
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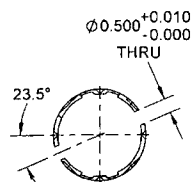
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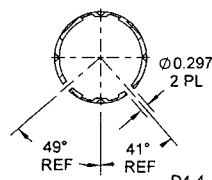
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SCALE 2X



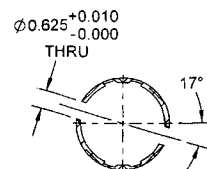
**DETAIL D**  
SCALE 2X



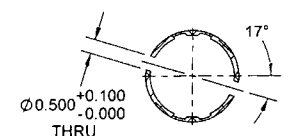
**SECTION E-E**  
SCALE 3X, 2 PL



**SECTION F-F**  
SCALE 3X, 17 PL



**SECTION G-G**  
SCALE 3X, 4 PL



**SECTION H-H**  
SCALE 3X, 4 PL

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MFG. APPR.		D2750	SHEET 4 OF 11
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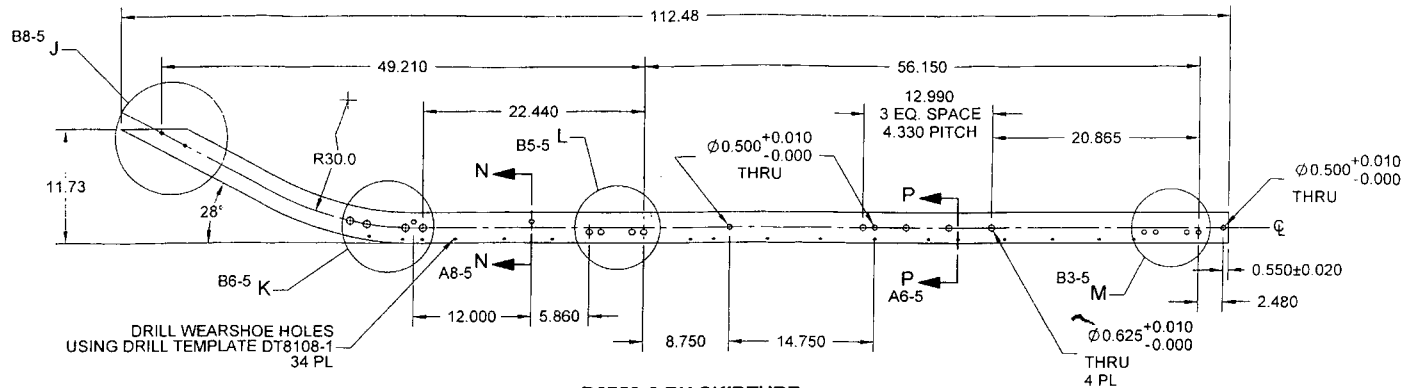
# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

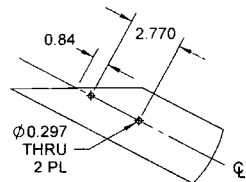
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 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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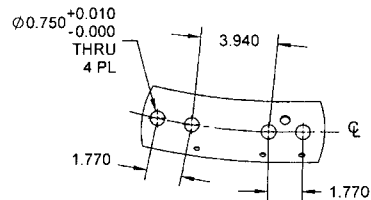
**NOTE:** Date & initial all entries



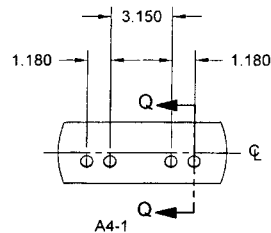
**D2750-2 RH SKIDTUBE**



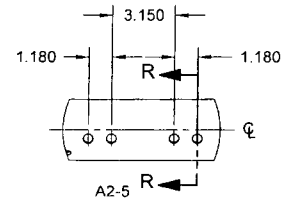
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SCALE 2X



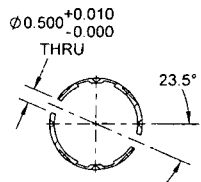
**DETAIL K**  
SCALE 2X



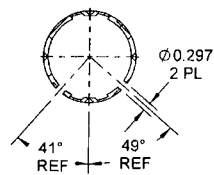
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SCALE 2X



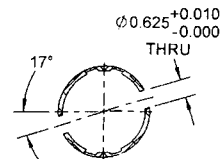
**DETAIL M**  
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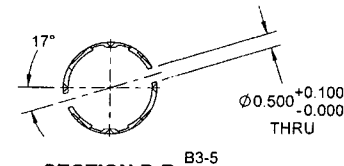
**SECTION N-N**  
SCALE 3X, 2 PL



**SECTION P-P**  
SCALE 3X, 17 PL



**SECTION Q-Q**  
SCALE 3X, 4 PL



**SECTION R-R**  
SCALE 3X, 4 PL

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MFG. APPR.		<b>D2750</b>	SHEET 5 OF 11
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**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

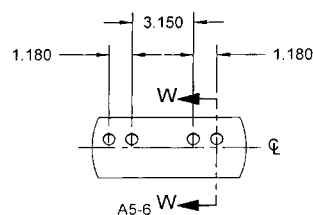
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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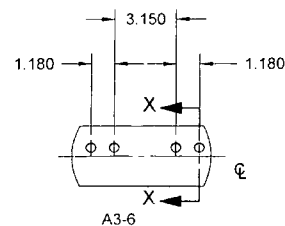
Technical drawing of a shaft assembly with dimensions and callouts:

- Overall Dimensions:**
  - Total length: 112.48
  - Section 1 length: 49.210
  - Section 2 length: 56.150
- Section 1 (Left):**
  - Feature: B8-6 S
  - Radius: R30.0
  - Angle: 28°
  - Height: 11.73
  - Distance from centerline to start of section: 19.690
  - Distance from start of section to centerline: 5.860
  - Feature:  $\varnothing 0.313^{+0.010}_{-0.000}$  THRU
  - Distance from centerline to end of section: 6.000
- Section 2 (Right):**
  - Feature: B4-6 U
  - Distance from centerline to end of section: 20.800
  - Feature: 3 EQ. SPACES 4.330 PITCH
  - Distance from end of section to centerline: 20.855
  - Feature:  $\varnothing 0.500^{+0.010}_{-0.000}$  THRU
- Intermediate Features:**
  - Feature:  $\varnothing 0.500^{+0.010}_{-0.000}$  THRU
  - Distance from centerline to feature: 23.01
  - Feature:  $\varnothing 0.313^{+0.010}_{-0.000}$  THRU
  - Feature:  $\varnothing 0.625^{+0.010}_{-0.000}$  THRU 4 PL
  - Feature: A7-6
  - Feature:  $\varnothing 0.550 \pm 0.020$
  - Distance from centerline to feature: 2.480
  - Feature:  $\varnothing 0.500^{+0.010}_{-0.000}$  THRU
  - Distance from centerline to feature: 1.125
- Other Callouts:**
  - DRILL WEARSHOE HOLES USING DRILL TEMPLATE DT8108-1 34 PL
  - Feature: B6-6 T
  - Distance from centerline to feature: 67.96

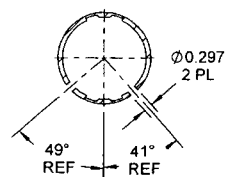
**DETAIL S**  
SCALE 2X



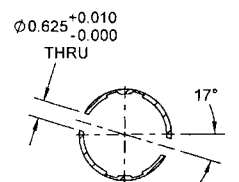
**DETAIL T** C5-6  
SCALE 2X



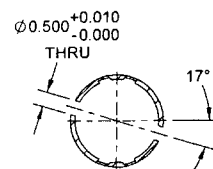
D3-6  
**DETAIL U**  
**SCALE 2X**



**SECTION V-V**  
**SCALE 3X, 17 PL**




**SECTION W-W** B6-6  
SCALE 3X, 4 PL



**SECTION X-X** B4-6  
SCALE 3X, 4 PL

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08-09-22 JTH

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DRAWN		PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2750	SHEET 6 OF 11
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DE APPR.		350 SKIDTUBE ASSEMBLY	NTS
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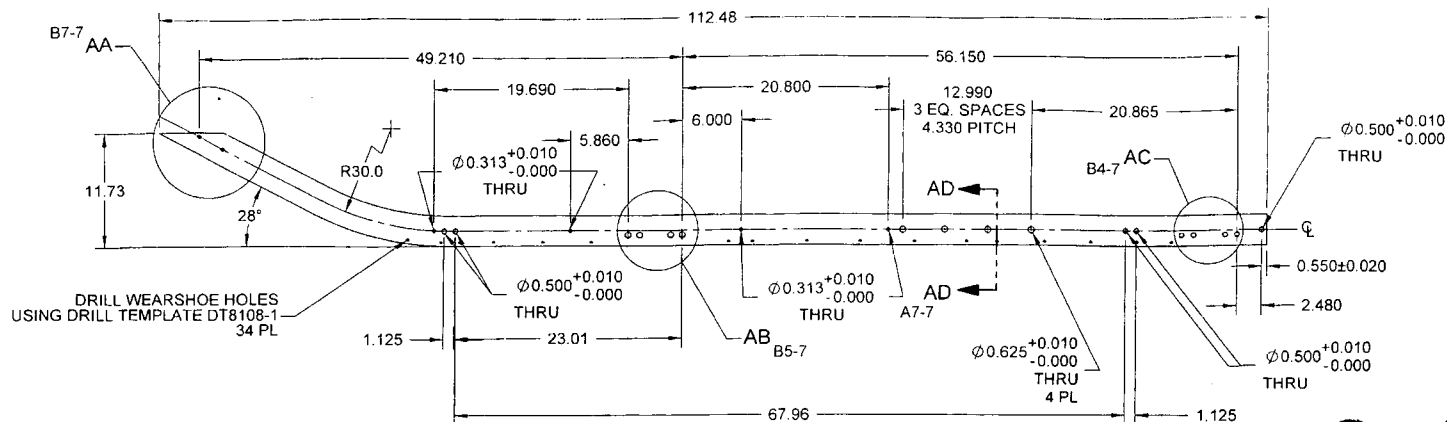
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

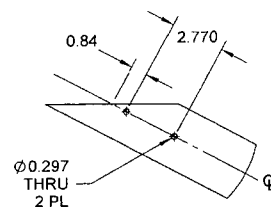
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

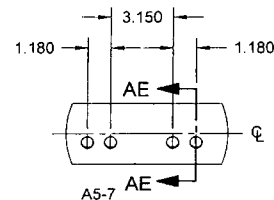
**NOTE:** Date & initial all entries



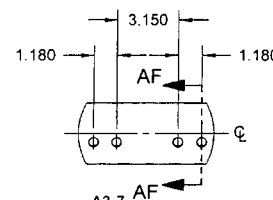
**D2750-4 RH SKIDTUBE**



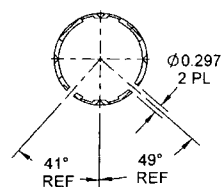
**DETAIL AA**  
D7-7  
SCALE 2X



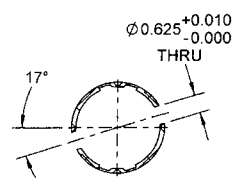
**DETAIL AB**  
C4-7  
SCALE 2X



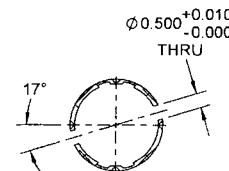
**DETAIL AC**  
D3-7  
SCALE 2X



**SECTION AD-AD**  
D3-7  
SCALE 3X, 17 PL



**SECTION AE-AE**  
B6-7  
SCALE 3X, 4 PL



**SECTION AF-AF**  
B4-7  
SCALE 3X, 4 PL

**RELEASED**

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MFG. APPR.		<b>D2750</b>	SHEET 7 OF 11
APPROVED		TITLE	SCALE
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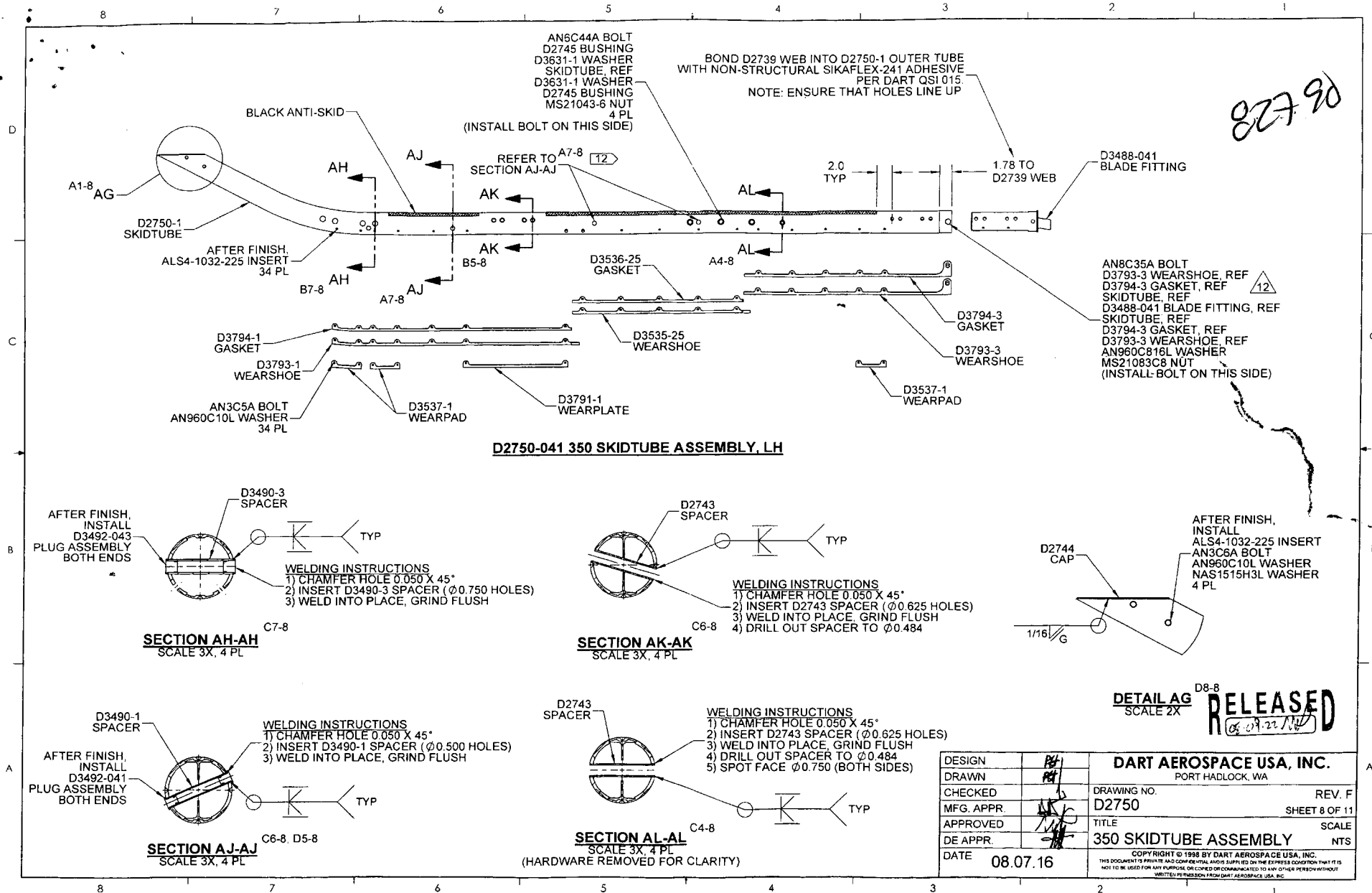
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

827 90



DESIGN	827 90	DART AEROSPACE USA, INC.	
DRAWN	827 90	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2750	SHEET 8 OF 11
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



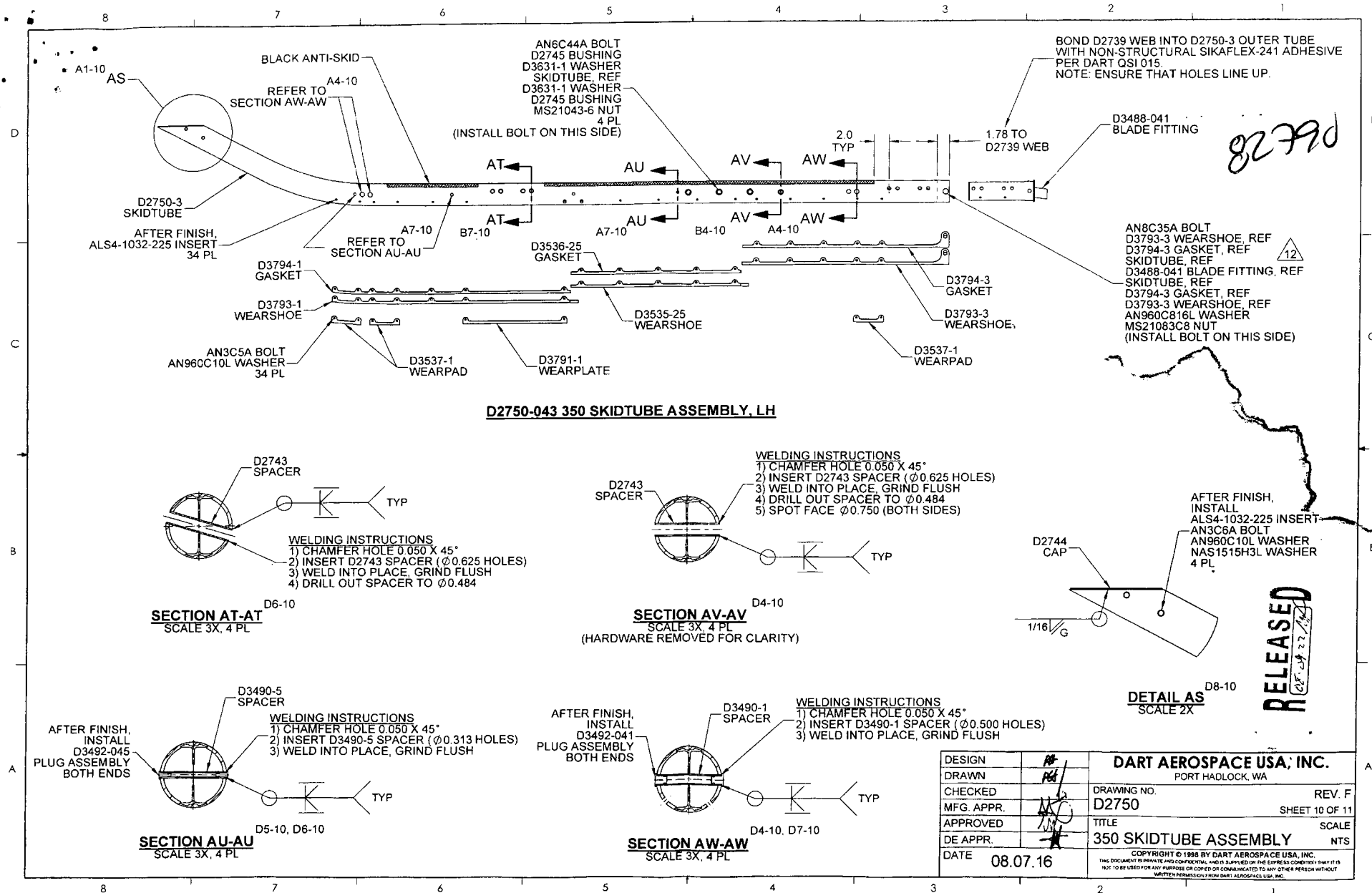
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
	21							

**NOTE:** Date & initial all entries



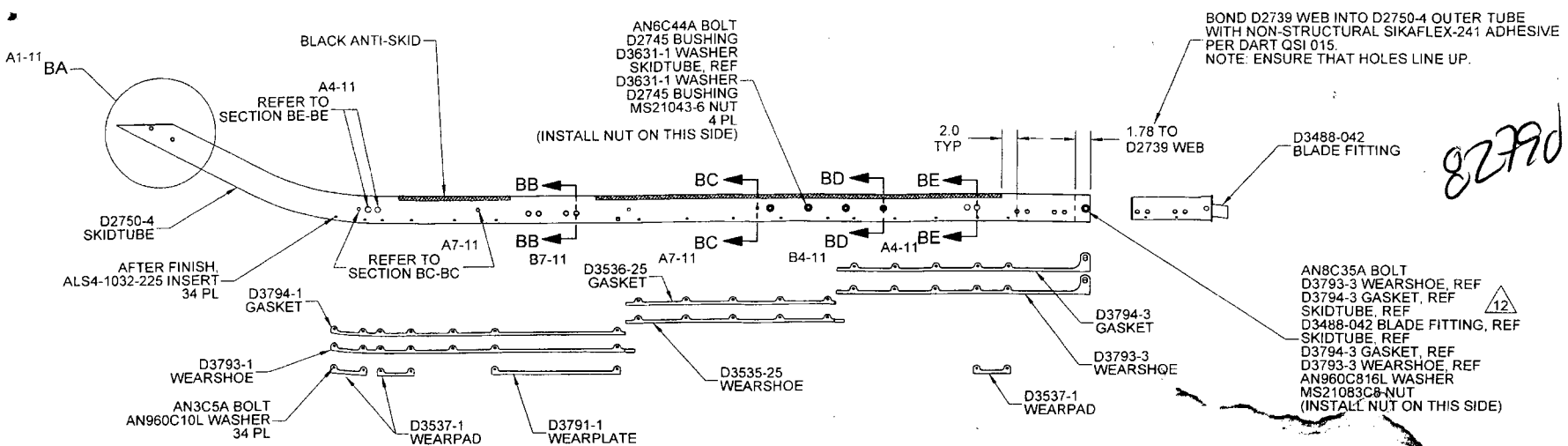
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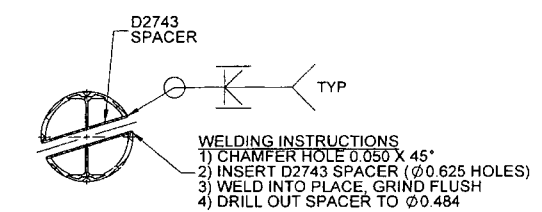
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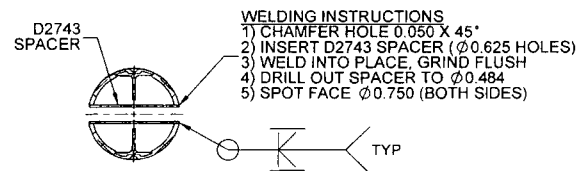
**NOTE:** Date & initial all entries



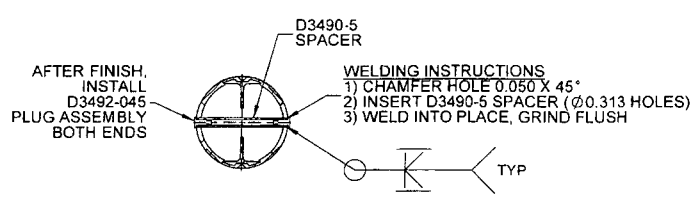
**D2750-044 350 SKIDTUBE ASSEMBLY, RH**



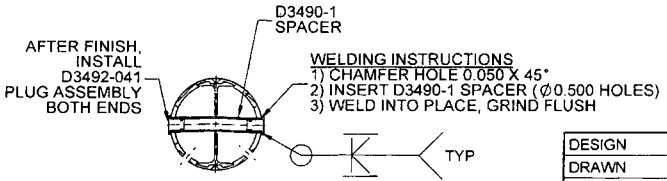
**SECTION BB-BB**  
SCALE 3X, 4 PL



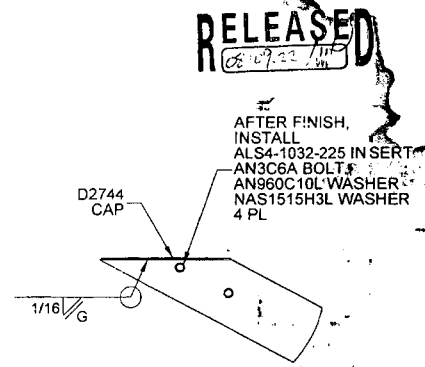
**SECTION BD-BD**  
SCALE 3X, 4 PL  
(HARDWARE REMOVED FOR CLARITY)



**SECTION BC-BC**  
SCALE 3X, 4 PL



**SECTION BE-BE**  
SCALE 3X, 4 PL



**DETAIL BA**  
SCALE 2X

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

NO. 289

AWS D17.1.2001  
QUALIFICATION TEST RECORD

Name: Barclay Elliott  
Job number: 81400  
Part number: A350-636-016  
Description: Stitching  
Welding Process: Tig[☒] Mig[ ]  
Base material: Alum  
Current: AC[☒] DC[ ]

TEST REQUIREMENTS AND RESULTS

Visual:

pass[☒] fail[ ]

Penetration:

pass[☒] fail[ ]

UNACCEPTABLE

Cracks:

pass[☒] fail[ ]

Undercut:

pass[☒] fail[ ]

Pin holes:

pass[☒] fail[ ]

Overlap (cold lap)

pass[☒] fail[ ]

Porosity (surface):

pass[☒] fail[ ]

Coloration:

pass[☒] fail[ ]

Qualifier David Sewell

Date of Test Coupon 12.04.17

Welder Barclay Elliott

Date of Test Coupon 12.04.17

The above named individual is qualified in accordance with AWS D17.1.2001 to weld